

Thursday, May 05, 2016 1:33:13 PM

647.7701
R145325
REV. A1

145325

Page 1

Revision ID:

Item Name: Strut Assembly

Start Date: 5/27/2016 **Start Qty:** 2.00

Required Date: 6/3/2016 **Req'd Qty:** 2.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: MCS Date: MAY 06 2016

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop  *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
-----------------	---------------------

647.7700 A1

110	Pick Kit	0.00
-----	----------	------

110

Packaging	Memo	0.00
-----------	------	------

Packaging

120	Weld per dwg A/R 4130 rod Batch: 121423	0.00
-----	---	------

120

Large Fab	Memo	0.00
-----------	------	------

Large Fab

1- ASSEMBLE AND WELD AS PER DWG

IMPORTANT DIMENSION IS 23.75"

130	QC9- Inspect visual per QSI004- Fusion Welds	0.00
-----	--	------

130

QC

Quality Control

2 16-11717
Jm

2 16.11.17

② 16-11-23

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[illegible]

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Page 3

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Work Order ID 145325

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145325

Page 4

Item ID: 647.7701

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Strut Assembly

Start Date: 5/27/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 6/3/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

Identify as per dwg & Stock Location: CCK-114

0.00

200

Packaging

Memo

0.00

Packaging

2
DAS
6
9-89

DEC 14 2016

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

DAS
21
9-89
DAS
21
9-89

DEC 14 2016

DEC 14 2016

Picklist Print

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Page 1

Work Order ID: 145325

145325

Parent Item: 647.7701

647 7701

Parent Item Name: Strut Assembly

Start Date: 5/27/2016

Required Date: 6/3/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 12.11.01 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
647.7710 *647 7710* Strut Tube		Manufactured	No				Each	10.0000	**	2			16-11-17 JLM
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				CCK114			10			2			
				138451			8						
				141105			2						
647.7712 *647 7712* Strut Tube		Manufactured	No				Each	19.0000	**	2			16-11-17 JLM
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				CCK114 145176			19			2			
				140985			19						
647.7713 *647 7713* Strut Thread		Manufactured	No				Each	18.0000	**	2			16-11-17 JLM
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				CCK114 148267			18			2			
				141018			18						



APICAL INDUSTRIES, INC.
dba DART AEROSPACE

ENGINEERING CHANGE NOTICE NO.

05110

SHEET 1 OF 1

DWG NO. 647.7700

REV: A

PREPARED
BY

A. QUAN

DATE: 08/21/15

EFFECT ON DWG

☐ INC. ☒ UNINC.

DWG TITLE: STRUT ASSY

APPROVED BY:

ENGR

MFG

QC

EFF.

CURRENT ORDER

TRANSACTION CODES (TC):

A-ADD
R-REVISE

C-CREATE
D-DELETE

REASON: REVISED FINISH CALLOUT AS PER ECR 15-209

SHEET 1, NOTES IS:

ACTION: UPDATE MO & WO

NOTES:

- 1 MATERIAL: 4130 STEEL PER AMS-T-6736, .50" OD, .083" WALL THK.
- 2 MATERIAL: 4130 STEEL PER AMS-T-6736, .375" OD, .075" WALL THK.
- 3 MATERIAL: 4130 STEEL PER AMS-T-6736, .324" OD.
- 4 FINISH: PRIME IAW MIL-P-2337J TYPE I CLASS N; 1-2 MIL MAX
5. DEBURR AND BREAK ALL SHARP EDGES
6. IDENTIFY IAW MPP-120.
- 7 WELD IAW MIL-STD-2219. TIG WELD WITH FILLER ROD
- 8 FINISH: CAD PLATE IAW QQ-P-416F CLASS I TYPE II
- 9 MASK THREAD PRIOR TO FINISH

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBMIT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 145325 MLS
16-05-06

TC PART NUMBER

QTY

DESCRIPTION

MATERIAL/SPECIFICATION

DOCUMENTS EFFECTED:

☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☐ BOM

CHANGE CATEGORY

☐ MAJOR ☐ MINOR

DER REVIEW REQUIRED

☐ YES ☐ NO

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NOTES:

- 1 MATERIAL: 4130 STEEL PER AMS-T-6736, .50" OD, .083" WALL THK.
- 2 MATERIAL: 4130 STEEL PER AMS-T-6736, .375" OD, .075" WALL THK.
- 3 MATERIAL: 4130 STEEL PER AMS-T-6736, .324" OD.
- 4 FINISH: PRIME IAW MIL-P-2337J TYPE I CLASS N; 1-2 MIL MAX
- 5 DEBURR AND BREAK ALL SHARP EDGES
- 6 IDENTIFY IAW MPP-120.
- 7 WELD IAW MIL-STD-2219. TIG WELD WITH FILLER ROD
- 8 FINISH: CAD PLATE IAW MIL-C-5541 CLASS 1A
- 9 MASK THREAD PRIOR TO FINISH

REV		DESCRIPTION	DATE	APPROVED
1		LAST PROTOTYPE REVISION PER		
2		INITIAL RELEASE		
3		INCORPORATED ECN DATA		

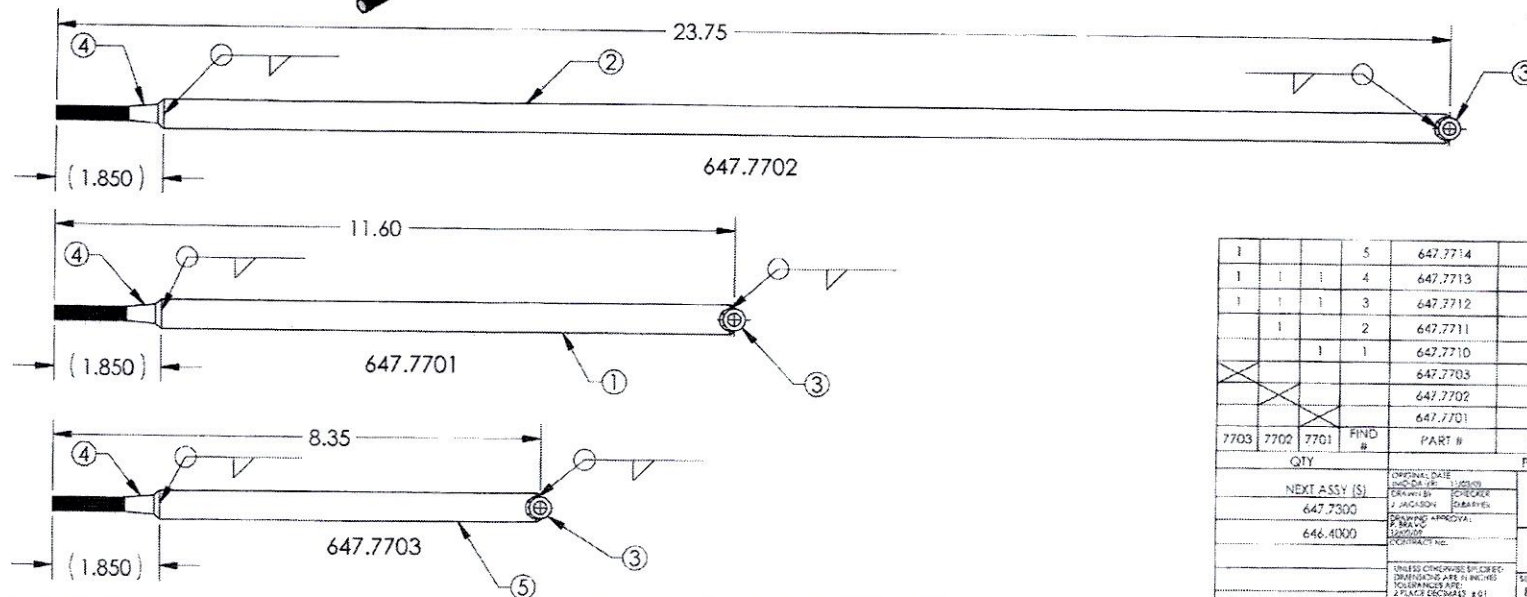
647.7701

647.7703

647.7702

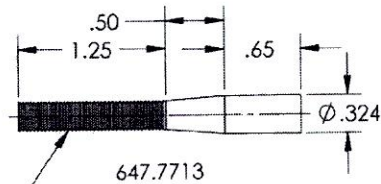
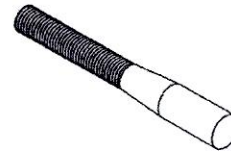
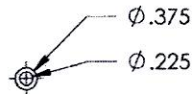
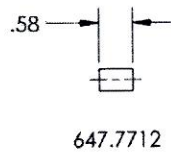
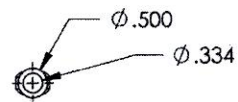
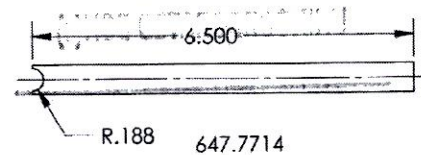
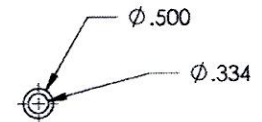
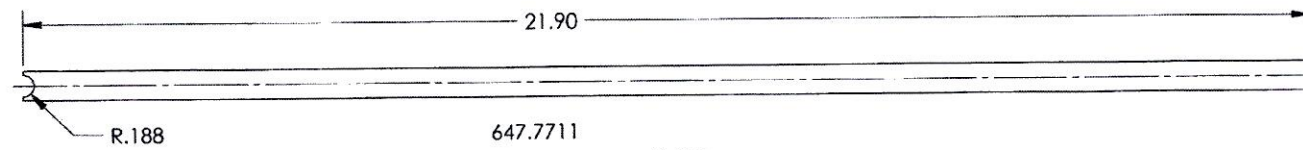
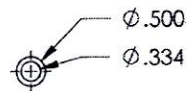
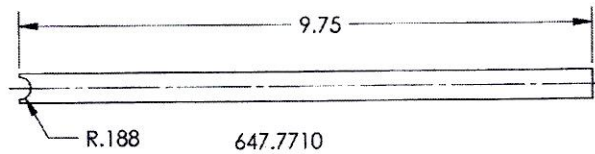
UNINCORPORATED ECN(s)

05110



QTY	REV	PART #	DESCRIPTION	MATL	SPEC.
1	1	5	647.7714	STRUT TUBE	△
1	1	4	647.7713	STRUT THREAD	△ △
1	1	3	647.7712	STRUT TUBE	△
1	1	2	647.7711	STRUT TUBE	△
1	1	1	647.7710	STRUT TUBE	△
1	1	1	647.7703	STRUT ASSY	△ △
1	1	1	647.7702	STRUT ASSY	△ △
1	1	1	647.7701	STRUT ASSY	△ △
7703	7702	7701	FIND #	PART #	DESCRIPTION
QTY	REV	PART #	DESCRIPTION	MATL	SPEC.
1	1	5	647.7714	STRUT TUBE	△
1	1	4	647.7713	STRUT THREAD	△ △
1	1	3	647.7712	STRUT TUBE	△
1	1	2	647.7711	STRUT TUBE	△
1	1	1	647.7710	STRUT TUBE	△
1	1	1	647.7703	STRUT ASSY	△ △
1	1	1	647.7702	STRUT ASSY	△ △
1	1	1	647.7701	STRUT ASSY	△ △
PARTS LIST					
APICAL INDUSTRIES					
2608 TEMPLE HEIGHTS DR.					
OCEANSIDE, CA. 92056-3512 (760) 724-5300					
STRUT ASSY					
REV	DATE	BY	CHKD	APP'D	REV
8	07/26/26	647.7700			A
SCALE: NONE					
SHEET 1 OF 2					

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1/4 - 28 THREAD

ORIGINAL DATE (M/D/YR) 11/02/89	APICAL INDUSTRIES		
DRAWN BY J. JACKSON	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300		
CHECKED BY D. BARKER			
DRAWING APPROVAL P. BRAYO			
CONTRACT NO.	STRUT ASSY		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 1 PLACE DECIMALS ±.01 2 PLACE DECIMALS ±.005 ANGLES ±.1°	SIZE CAGE CODE 07M26	DESIGN NO. 647.7700	REV. A
	SCALE: NONE		SHEET 2 OF 2

APICAL INDUSTRIES
 2608 TEMPLE HEIGHTS DR.
 OCEANSIDE, CA. 92056-3512 (760)724-5300

STRUT ASSY



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO34422**

Purchase Order Date 11/24/2016

PO Print Date 11/24/2016

Page Number 1 of 2

Order From :

GROUP ALTECH
2455 HALPERN

VC-ALT01

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

NOV 24 2016

ST LAURENT, MONTREAL H4S 1N9

Contact Name

Vendor Phone 514-335-3666

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms Net 30

Currency CAD

FOB FOB Origin

Ship To Contact

Ship To Phone

Ship Via:

Ship Acct:

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	153192	647.7702 STRUT	12/2/2016 Yes 12/2/2016		6.00	29.50	\$177.00
Cad Plating is to be done per QQ-P-416F Class I Type II. PLEASE NOTE: HYDROGEN EMBRITTLEMENT IS INCLUDED IN PRICING PER UNIT							
DEC 09 2016							
Line Total:							\$177.00
2	147523	647.7701 STRUT	12/2/2016 Yes 12/2/2016		2.00	29.50	\$59.00
Cad Plating is to be done per QQ-P-416F Class I Type II. PLEASE NOTE: HYDROGEN EMBRITTLEMENT IS INCLUDED IN PRICING PER UNIT							
DEC 09 2016							
Line Total:							\$59.00
3	147523	647.7701 STRUT	12/2/2016 Yes 12/2/2016		2.00	29.50	\$59.00
Cad Plating is to be done per QQ-P-416F Class I Type II. PLEASE NOTE: HYDROGEN EMBRITTLEMENT IS INCLUDED IN PRICING PER UNIT							
DEC 09 2016							

Note:

68-6
38
DAS

11/24/2016



2455, Halpern, Saint-Laurent, QUÉBEC, H4S 1N9
Tel.: (514) 335-3666 Fax.: (514) 335-3868
Internet : www.groupaltech.com

**Bon de livraison / Packing Slip
et / and
Certificat de conformité / Certificate of Compliance**

Bon-Livraison / Pk.Slip # : 123347-1 06/12/2016
Bon-Commande. / W.Order # : 123347
Client P.O. # : PO34422
Transport :

Envoyé à / Ship to

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY
ONTARIO, CANADA K6A 1K7

Commandé par / Order by

DART AEROSPACE LTD (1427)
1270 ABERDEEN STREET
HAWKESBURY
ONTARIO, CANADA K6A 1K7

#	<u>No. Job</u> <u>No. Réf</u>	<u>NoSerie / Part Number</u> <u>Nom Produit / Product</u>	<u>Traitement</u> <u>Process</u>	<u>Poids</u> <u>Weight</u>	<u>Qté</u> <u>Qty</u>	<u>Envoyé</u> <u>Sent</u>	<u>A venir</u> <u>BO</u>
1	UNIT	647.7702 Rev.	CADMIUM YELLOW PER QQ-P-416F TY:2 CL:1 + HYDROGEN ENBRITAMENT RELIEF (BAKE)	0.00	6	6	0
2	UNIT	647.7701 Rev.	CADMIUM YELLOW PER QQ-P-416F TY:2 CL:1 + HYDROGEN ENBRITAMENT RELIEF (BAKE)	0.00	2	2	0
3	UNIT	647.7701 Rev.	CADMIUM YELLOW PER QQ-P-416F TY:2 CL:1 + HYDROGEN ENBRITAMENT RELIEF (BAKE)	0.00	2	2	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

AK

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
Our financial and legal responsibility will not be higher than the amount of invoice.